

Work Order ID 67687



Page 1

Tuesday, March 29, 2011 11:24:53 AM

Item ID:	D206-642-312	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Skidtube RH					
Start Date:	3/29/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/1/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-642	N								

100	DOCUMENT CONTROL	0.00							
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-642-312	CHG006							

8/11/06/07

JB BG 11-4-26

110	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

JB 11/04/27

120	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

8/11/06/07

B67681

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67687

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Tuesday, March 29, 2011 11:24:54 AM

Item ID: D206-642-312

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube RH

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-642-312 Location: <u>8C</u> PPP Rev: <u>F</u>								
140 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/6/7 (U)

11/6/8 (U)

11-06-7
E

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:25:00 AM

Page 1

Work Order ID: 67687

Parent Item: D206-642-312

Parent Item Name: Skidtube RH



Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: J 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM/EC
 IPP Rev: K 07-12-04 ECN 1080p DD verified by: ec
 IPP Rev: L 08-09-29 as per DSI9421 DD verified by: EC IPP Rev: M
 09-03-02 as per DSI9440 rev.a verified by: EC
 IPP Rev: N 09-03-03 as per DSI9421 rev.b verified by: EC IPP Rev: O
 as per REV.N DD 10.04.19 verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D206-642-341 Replacement Skidtube		Manufactured	No			110	Each	3.0000	1	1			

Location	Loc Qty	Loc Code
FG082	3	
36550	1	
44043	1	
44044	1	

D206-648-013 GHW Modification		Manufactured	No			110	Each	4.0000	1	1			
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Location	Loc Qty	Loc Code
FG120	4	
67296	4	

D2932-2 Saddle RH Out, 206		Manufactured	No			110	Each	7.0000	1	1			
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Location	Loc Qty	Loc Code
ST421	3	
66381	3	
ST428A	4	
62080	4	

67681

67297 SP JB 11/04/22

62080

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67687

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2933-2
Saddle RH In, 206

Manufactured No

110 Each

5.0000



1

1

✓

JB

Location

Loc Qty

Loc Code

ST421

2

66383

2

ST428

3

63585

3

63585

D2938-2
Saddle RH Out, 206

Manufactured No

110 Each

4.0000



1

1

✓

JB

Location

Loc Qty

Loc Code

ST421

4

66039

2

66384

2

66039

D2939-2
Saddle RH In, 206

Manufactured No

110 Each

2.0000



1

1

✓

JB
669031
11630

Location

Loc Qty

Loc Code

ST421

2

66385

2

AN3-41A
Bolt

Purchased No

110 Each

368.0000



8

8

✓

JB
11/04/27

Location

Loc Qty

Loc Code

ST354

369

112431

1

114941

68

115936

100

116191

200

8119941

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 67687

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2652

Manufactured No

110 Each

364.0000 16 16 ✓

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST019

320

65049

32

66124

121

66934

167

66934

8

MS21042L3

Purchased No

110 Each

2,189.000 8

Nut

Location

Loc Qty

Loc Code

ST300

2189

116391

589

116540

800

116549

800

116540

8

AN960JD10

NAS1149D0363J

Purchased No

110 Each

0.0000 8

Washer

AN5-10A

Purchased No

110 Each

152.0000 4

Bolt

Location

Loc Qty

Loc Code

ST337

152

115700

2

116704

50

116924

50

117010

50

117010

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, March 29, 2011 11:25:01 AM

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Work Order ID: 67687

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

AN5-11A
Bolt
Purchased No

110 Each 61.0000 4 4

✓

JB

SD

Location Loc Qty Loc Code

ST337 61

115422 6

116419 25

116978 30

110 Each 0.0000 8

116419 X3

116978 X1

8 ✓

m117291

JB

SD

AN960JD516
Washer
AN4-6A
Bolt
Purchased No

NAS1149D0563J

110 Each 1,079.000 12 12

✓

JB

SD

Location Loc Qty Loc Code

ST356 1079

115936 200

116191 79

116400 400

116924 400

110 Each 0.0000 24 24

✓

m117065

JB

SD

AN960JD416
Washer
MS21042L4
Nut
Purchased No

NAS1149D0463J

110 Each 3,324.000 12 12

✓

JB

11/04/27 SD

Location Loc Qty Loc Code

ST300 3324

116188 1324

116823 2000

116823

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67687

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D3407-043

Manufactured No

110 Each

1.0000

1



Tow Ring



68339 11/5/11

Location

Loc Qty

Loc Code

ST420

6

66386

6

ST464

1

64071

1

D3456-1

Manufactured No

110 Each

62.0000

1



Washer



1 ✓
B68748 JB

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

55

64282

5

66848

50

D3457-1

Manufactured No

110 Each

24.0000

2



Washer



2 ✓
JB 11/64/2

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

14

66030

14

66030

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67687

Parent Item: D206-642-312

Parent Item Name: Skidtube RH

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

737.0000

1

1

✓



Nut



JB SP

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

697

116188

397

116549

300

116188

AN4C5A

Purchased

No

110

Each

544.0000

1

1

✓



BOLT



JB SP

Location

Loc Qty

Loc Code

FP-B

117

112243

117

ST345

427

112243

427

112243

AN960C416

NAS1149C0463

Purchased

No

110

Each

0.0000

1

1

✓



washer

D3413-1

Manufactured

No

110

Each

48.0000

1

1

✓



Ring



m 116900

JB SP

JB 11/04/2 SP

Location

Loc Qty

Loc Code

ST420

22

62961

8

66387

14

ST473

26

53446

1

65294

10

66945

15

65294

Tuesday, March 29, 2011 11:25:01 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 11:25:01 AM

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Work Order ID: 67687

Parent Item: D206-642-312

Parent Item Name: Skidtube RH



Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

D2712
Set Screw

Manufactured No

110 Each

571.0000

10

10 ✓



JB SP

Location

Loc Qty

Loc Code

FG 50
29962 50
ST012 252
66955 252
ST021 269
61331 19
65115 250

D2934
Saddle Spacer

Manufactured No

110 Each

21.0000

2

2 ✓



JB 11/04/27 SP

Location

Loc Qty

Loc Code

FG 6
31929 6
ST027 15
66043 15

D2935
Saddle Spacer

Manufactured No

110 Each

80.0000

2

2 ✓



JB 11/04/27 SP

Location

Loc Qty

Loc Code

ST027 80
63558 9
66564 71

66564

Tuesday, March 29, 2011 11:25:02 AM

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

4.5 206 L/L-1/L-3/L-4/407 LOW & HIGH GEAR SKIDTUBES

Item	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	Part Number	Description
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT
1			1			D2650-5	SKIDTUBE ASSEMBLY
2A			14			D2651-1	* PLUG ⁽¹⁾
2B			14			D2651-3	* O-RING ⁽¹⁾
3			1			D2646	* AFT CAP ⁽¹⁾
4			2			MS27039-1-08	* SCREW ⁽¹⁾
5			2			AN960JD10L	* WASHER ⁽¹⁾
6	1					D2932-1	SADDLE, FWD OUT, LH
6		1				D2932-2	SADDLE, FWD OUT, RH
7	1					D2933-1	SADDLE, FWD IN, LH
7		1				D2933-2	SADDLE, FWD IN, RH
8	1					D2938-1	SADDLE, AFT OUT, LH
8		1				D2938-2	SADDLE, AFT OUT, RH
9	1					D2939-1	SADDLE, AFT IN, LH
9		1				D2939-2	SADDLE, AFT IN, RH
10	8	8				AN3-41A	BOLT
11	16	16				D2652	BUSHING
12A	8	8				MS21042-3	NUT (OR MS21042L3)
12B	8	8				AN960JD10	WASHER
13	4	4				AN5-10A (OR AN5-11A)	* BOLT ⁽²⁾
14	4	4				AN5-11A (OR AN5-12A)	* BOLT ⁽²⁾
15	8	8				AN960JD516	WASHER
16	12	12				AN4-6A	BOLT
17	24	24				AN960JD416	WASHER
18	12	12				MS21042-4	NUT (OR MS21042L4)
20A			6	6		D3537-1	WEARPAD (REPLACES D2648-3)
21A			1	1		D3537-3	WEARPAD (REPLACES D3429-1)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)
22B			1	1		D3536-11	GASKET
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)
23B			1	1		D3536-23	GASKET
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)
24B			1	1		D3536-35	GASKET
26A			54	54		MS27039C1-08	SCREW
26B			54	54		AN960C10L	WASHER
26C			54			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1				D3407-043	TOW RING ASSEMBLY (REPLACES D2968-043)
31	1	1				D3456-1	WASHER
32	1	1				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING (REPLACES D2655)
37	10	10				D2712	SET SCREW
38	2	2				D2934	SADDLE SPACER
39	2	2				D2935	SADDLE SPACER
40					2	D3414-041	GHW LUG (REPLACES D2659)
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

NOTES: ⁽¹⁾ DENOTES THAT PART IS INCLUDED WITH D2650-5 ASSEMBLY ABOVE⁽²⁾ CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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Date: 09.09.09

